

Work Order ID 82137

82137

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March-23-12 10:47:50 AM

Item ID: D2151 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Packer Doubler, Hinge
 Start Date: 23/03/2012 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 06/04/2012 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/23 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2151	Rev B								

100 FLOW WATER JET 0.00
100 24 Jm
 Waterjet Memo 0.00 12-4-14
 FLOW CNC Waterjet 1-Cut as per Dwg D2151 Dwg Rev: B Prog Rev: B 2-
 2024 0.040 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110 24 Jm
 QC Memo 0.00 12-4-14
 Quality Control

120 QC8- Inspect parts - second check 0.00
120 24 Jm
 QC Memo 0.00 8/12/14
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Debur								
140		0.00							
140	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>2:10</u>								
	FINISH TIME: <u>32:00</u>								
	OVEN TEMPERATURE: <u>2740</u>								

ml21134

mla L

(24) 7/6 12-4-16

24X ✓ m/z 12/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D2151

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Packer Doubler, Hinge

Start Date: 23/03/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 06/04/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

24 0 12-4-17

170

Identify as per dwg & Stock Location: **S5**

0.00

170

Packaging

Memo

0.00

Packaging

24 0 12-4-17

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12 4/19 17

12-04-18

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-23-12 10:47:53 AM

Page 1

Work Order ID: 82137

82137

Parent Item: D2151

D2151

Parent Item Name: Packer Doubler, Hinge

Start Date: 23/03/2012

Required Date: 06/04/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C00.10.23Re-format (mpp 2101)EC
IPP Rev:D 06-04-28 Manufactured on Water Jet JLM
IPP Rev:E 06-11-24 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased		No		110	sf	191.1584	0.035	0.884211			

M2024T3S 040

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

191.158421

117684

21.318421

120196

59.41

120605

110.43

120605
(24)

Jm
12-4-14.

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DART AEROSPACE LTD		Work Order: 82137
Description: Packer		Part Number: D2151
Inspection Dwg: D2151	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.101	✓		Vern	HB-02
Ø0.171	+0.005/-0.000	0.176	✓		Vern	HB-02
0.231	+/-0.010	0.226	✓		Vern	HB-02
1.217	+/-0.010	1.213	✓		Vern	HB-02
2.194	+/-0.010	2.187	✓		Vern	HB-02
2.300	+/-0.010	2.292	✓		Vern	HB-02
1.560	+/-0.010	1.555	✓		Vern	HB-02
0.250	+/-0.010	0.243	✓		Vern	HB-02
1.328	+/-0.010	1.320	✓		Vern	HB-02
0.342	+/-0.010	0.337	✓		Vern	HB-02
0.740	+/-0.010	0.735	✓		Vern	HB-02
2.050	+/-0.010	2.045	✓		Vern	HB-02
0.040	+/-0.010	0.040	✓		Vern	HB-02

Measured by: SM	Audited by: S	Prototype Approval:	N/A
Date: 12-4-14	Date: 12/4/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	

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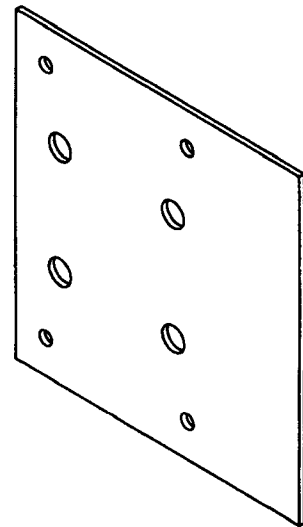
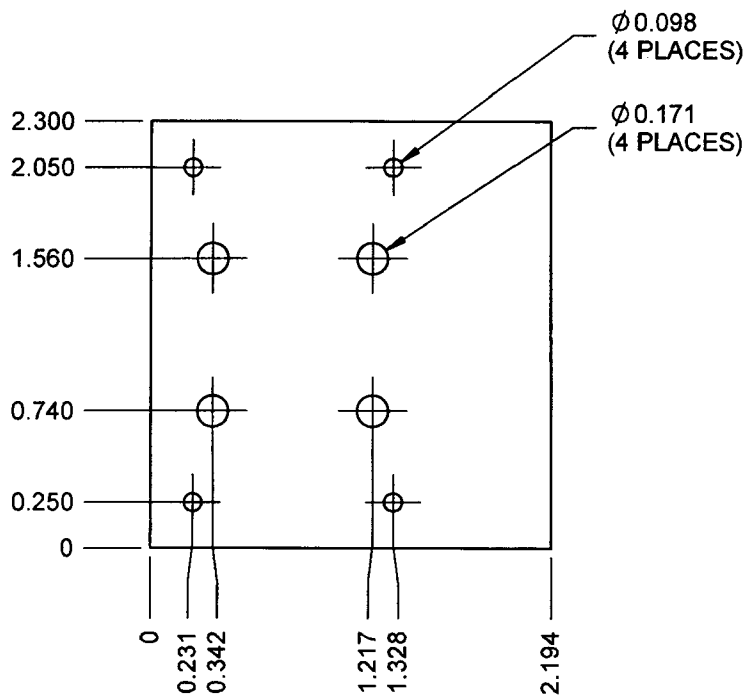
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2151	REV. B SHEET 1 OF 1
DATE 06.10.13		TITLE PACKER	SCALE 1:1
REV	DATE	DESCRIPTION	
A	95.05.01	NEW ISSUE	
B	06.10.13	UPDATE DRAWING	

RELEASED

06.11.20 **[Signature]**



D2151 PACKER

12/03/23
NO. 82137 MJS
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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